

Work Order ID 104686

104686

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Item ID: D4770-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 7/12/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 7/19/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4770	A

100		0.00							
100									
Cold Saw	Memo	0.00							
Hyd Mech	Cut blanks as per dwg								

110		0.00							
110									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB182 & dwg D4770-1, FOLIO REV: <u>N/A Manual</u> DWG REV: <u>A</u>								
	2-Deburr as required								

EXTRA MATERIAL WILL BE CUT AT ASSEMBLY

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		13-07-16		8			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		13/07/16		8	8		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>W2001</u> Memo	0.00 0.00				(x8) me	13-07-16		

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/12/13 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 7/19/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

[illegible]

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCJ 13-07-18

MF
13-7-14

Picklist Print

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Work Order ID: 104686
Parent Item: D4770-1
Parent Item Name: Bar

Start Date: 7/12/13
Start Qty: 8.00

Required Date: 7/19/13
Required Qty: 8.00

Comments: IPP REV:A 13.04.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	331.2483	1.666	14.029474			

Location

MAT049

124518

m126151

Loc Qty

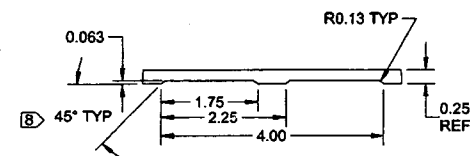
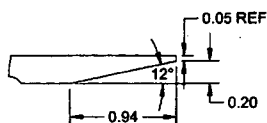
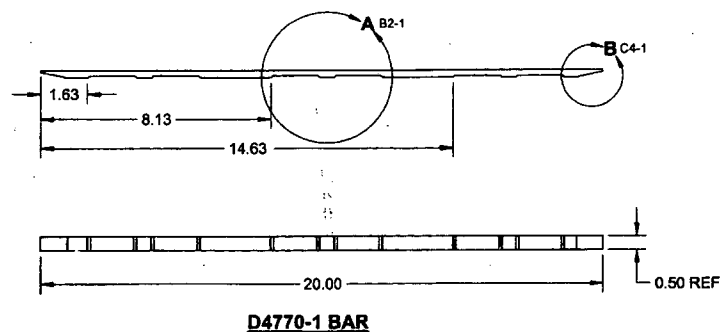
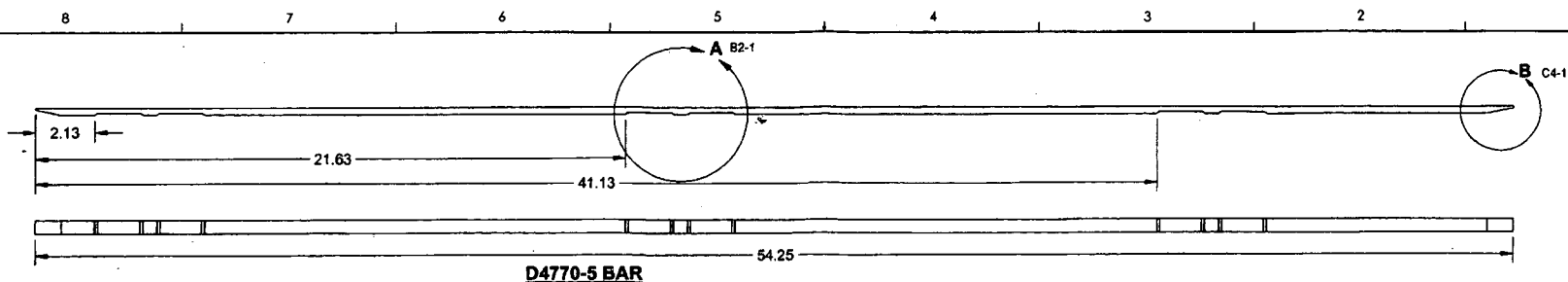
331.2483

28.365

302.8833

Loc Code

14.5 13-07-15

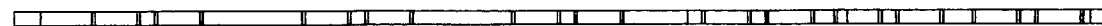
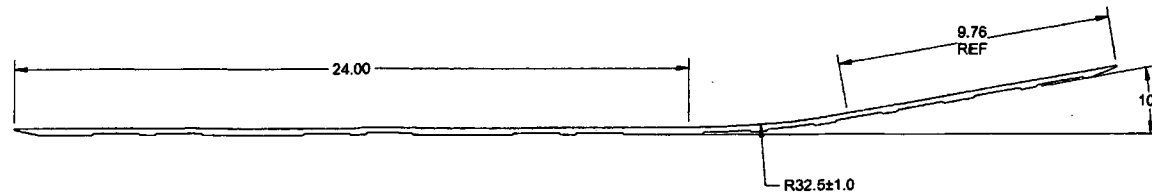


NOTES:

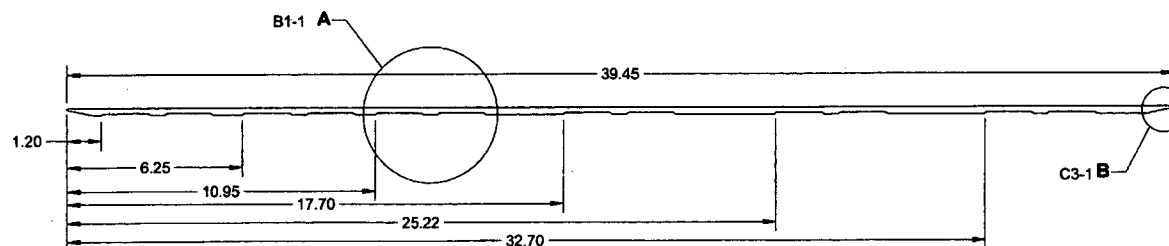
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4770-1= 60 lbs, D4770-5=1.84 lbs
- 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING

RELEASED
2013-03-25

A NEW RELEASE		DB	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4770	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	13.02.13	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION OR FOR ANY OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4770-3 BAR
(MAKE FROM D4770-3F)



D4770-3F BAR
(FLAT PATTERN)

RELEASED
2013-03-25

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4770-3=1.22 lbs.

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4770	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BAR	NTS
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